

Work Order ID 67251

Monday, March 14, 2011 10:43:40 AM

BLUE



Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date:

11/03/14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

Work Order ID 67251



Page 2

Monday, March 14, 2011 10:43:40 AM

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod ☒ M111385 / M116577 BE 11/03/21

4-Grind weld flush to cap on top surface only. BE 11/03/21

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube



11-3-16

11/3



BE 11-03-23

Work Order ID 67251

Monday, March 14, 2011 10:43:40 AM



Page 3

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

8 w/03/25

8 w/07/05

④

BB 11/03/28

Work Order ID 67251

Monday, March 14, 2011 10:43:40 AM



Page 4

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



11-3-28

Work Order ID 67251

Monday, March 14, 2011 10:43:41 AM



Page 5

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

0.00

Skidtubes

Memo1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.
cure time before cutting☐Start Date: 11/03/31 ☐Time: ☐ 11:00☐Finish Date: 11/03/31 ☐Time: ☐ 11:30A/R ☐ Sikaflex-291 ☐ 116040/116044Sikaflex expiry date: ☐

11/09/30 / 12/01/15

3 BE1/03/28

BB 11/03/31

Work Order ID 67251

Monday, March 14, 2011 10:43:41 AM

Page 6

Item ID: D206-642-441

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00

Required Date: 3/25/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

160

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R Aluminum Rod mill 385

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr

BE 11/04/06

DP 11-4-7

Work Order ID 67251

Page 7

Monday, March 14, 2011 10:43:41 AM

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 Skidtubes	HandFinishing	0.00							
Skidtubes	Memo Install D2680-041 Nut Plate as per Dwg D2650	0.00	DP	11-4-7					
180 QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00	Sulaylos						
190 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00	Sulaylos						

Work Order ID 67251



Page 8

Monday, March 14, 2011 10:43:41 AM

Item ID:	D206-642-441	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Replacement Skidtube					
Start Date:	3/14/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	3/25/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Pressure Wash per QSI005 4.3	0.00							
	HandFinish								
	Memo	0.00							
Hand Finishing	✓ Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.								
205	Spray Painting per QSI005 4.2	0.00							
	SprayPaint								
	Memo	0.00							
Spray Painting	Spray Painting: prime grey B: 117319 spray paint delfleet blue B: 115985 clear delfleet B: 117113								
220	QC14 Inspct Part Finish	0.00							
	QC								
	Memo	0.00							
Quality Control									

225

QC14 Inspct Paint
Permanent Change

11 04 27 0

Work Order ID 67251

Page 9

Monday, March 14, 2011 10:43:41 AM

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☐ M116040Sikaflex expiry date: ☐ 11/08

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☐ M116040Sikaflex expiry date: ☐ 11/08

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: M117315

1 of 11/08/27

Work Order ID 67251

Page 10

Monday, March 14, 2011 10:43:41 AM

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

11	04	28	17
----	----	----	----

250		0.00							
-----	--	------	--	--	--	--	--	--	--



Packaging	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Identify and pack for shipping as per PPP D206-642-441

Location:

PPP Rev:

PPP 67246

11/5/11	03	01
---------	----	----

260	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

11/5/11	05	06
---------	----	----

Picklist Print

Monday, March 14, 2011 10:43:36 AM

Page 1

Work Order ID: 67251

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube



Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 05.10.11 Added D3429-1 per CHG002 KJ/CP/ILM
 IPP Rev:I 08-05-01 add QC3 DD verified by:EC
 IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K
 10.09.27 SS washers for wearplates EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620

 Skidtube, 206 Skidtube

Manufactured No

110

Each

15.0000

1

1

Location

Loc Qty

Loc Code

LG

15

62684

6

64784

9

D2646

 Aft Cap

Manufactured No

110

Each

71.0000

1

1

Location

Loc Qty

Loc Code

FP-4

1

57332

1

FP6

16

52663

3

62678

12

63633

1

Return 2010

54

62678

54

D2647

 Cap

Manufactured No

140

Each

51.0000

1

1

Location

Loc Qty

Loc Code

LG002

51

55352

51

Handwritten notes:
 11-3-16
 11-3-16
 11-3-16

Handwritten notes:
 69019
 1367263

Handwritten notes:
 8/11/23/21

Picklist Print

Monday, March 14, 2011 10:43:36 AM

Work Order ID: 67251



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-7 Manufactured No



Web

67061

160 Each

4.0000

1

1



1

11/03/31

Location

Loc Qty

Loc Code

LG

67061

4

67016

4

1

1

CCR264SS3-3

Purchased No



Cherry Rivet

170 Each

332.0000

2

2



Location

Loc Qty

Loc Code

ST311

332

112314

4

113539

44

113973

88

117086

196

2

11-4-7

D2649

Manufactured No



Cross Bolt Spacer

170 Each

120.0000

23

23



Location

Loc Qty

Loc Code

LG001

120

58545

2

60652

4

61496

2

62889

11

63359

3

65317

98

23

11/04/06

D2680-041

Manufactured No



Nut Plate

170 Each

14.0000

1

1



Location

Loc Qty

Loc Code

ST020

14

55366

14

11-4-7

Monday, March 14, 2011 10:43:36 AM

Shop Packet Print

Picklist Print

Monday, March 14, 2011 10:43:36 AM

Work Order ID: 67251

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 Purchased No

230 Each

626.0000 60 60



Insert



Handwritten: 11/04/27

Location

Loc Qty

Loc Code

PKG11

491

1117331

114723

42

Handwritten: X60

116864

449

ST281

135

110511

10

114654

39

115911

86

AN960JD10L NAS1149D0332J Purchased No

230 Each

4.0000 2 2



Washer



Handwritten: 11/04/27

Location

Loc Qty

Loc Code

ST335

4

1117291

11912

4

Handwritten: X2

AN960JD416 NAS1149D0463J Purchased No

230 Each

30.0000 1 1



Washer



Handwritten: 11/04/27

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

1116805

115622

6

Handwritten: VI

Picklist Print

Page 4

Monday, March 14, 2011 10:43:36 AM

Work Order ID: 67251



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

230

Each

1,837.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

MEZZ

1837

110139

2

110153

35

111359

5

112314

2

114436

448

114450

31

114859

1314

D2651-1

Manufactured

No

230

Each

571.0000

22

22



Plug

Location

Loc Qty

Loc Code

FP

189

51530

152

62638

37

fpa

382

53349

205

57869

117

66445

60

D2651-3

Manufactured

No

230

Each

404.0000

22

22



O-Ring

Location

Loc Qty

Loc Code

FP

404

46114

12

61962

392

(2)

11-4-7

1367263

X22

11/04/27

X22

Picklist Print

Monday, March 14, 2011 10:43:37 AM

Work Order ID: 67251

Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011



Required Date: 3/25/2011

Start Qty: 1.00



Required Qty: 1.00

D3535-15 Manufactured No 230 Each 22.0000 1 1
  22 11/01/27
 Wearshoe

Location	Loc Qty	Loc Code
FP18	22	
63569	3	
66238	6	<u>Y1</u>
66558	13	

D3535-23 Manufactured No 230 Each 18.0000 1 1
  23 11/01/27
 Wearshoe

Location	Loc Qty	Loc Code
FP021	18	
63571	4	
66236	13	<u>Y1</u>

D3535-37 Manufactured No 230 Each 7.0000 1 1
  37 11/01/27
 Wearshoe

Location	Loc Qty	Loc Code
FP	7	
56101	1	
62716	6	<u>Y1</u>

Picklist Print

Monday, March 14, 2011 10:43:37 AM

Work Order ID: 67251



Parent Item: D206-642-441





Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011



Required Date: 3/25/2011

Start Qty: 1.00



Required Qty: 1.00

D3536-15 Manufactured No 230 Each 36.0000 1 1
  sl 11/04/27
 Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	1	
56055	1	
FP011	34	
<u>63568</u>	8	X1
66559	26	
FP11	1	
59238	1	

D3536-23 Manufactured No 230 Each 36.0000 1 1
  sl 11/04/27
 Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	10	
<u>66240</u>	10	
FP011	26	X1
63570	1	
66560	25	

D3536-37 Manufactured No 230 Each 24.0000 1 1
  sl 11/04/27
 Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	24	X1
<u>63237</u>	12	
66823	12	

Picklist Print

Monday, March 14, 2011 10:43:37 AM

Work Order ID: 67251

Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011



Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No 230 Each 28.0000 6 6

 Wearpad  HL 11/04/20



Location	Loc Qty	Loc Code
FP017	28	B 66935
37749	5	
65057	23	

x6

D3537-3 Manufactured No 230 Each 20.0000 1 1

 Wearpad  HL 11/04/20



Location	Loc Qty	Loc Code
FP17	20	
65929	20	

x1
 2
HL 11/04/20

MS27039-1-08 Purchased No 230 Each 1,059.000 2 2

 Screw  HL 11/04/20

Location	Loc Qty	Loc Code
ST291	1059	
110835	319	
115108	740	

x2

MS27039-4-06 Purchased No 230 Each 91.0000 1 1

 Screw  HL 11/04/20

Location	Loc Qty	Loc Code
ST292	91	
109061	4	
115460	87	

x1

Picklist Print

Page 8

Monday, March 14, 2011 10:43:37 AM

Work Order ID: 67251

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-08

Purchased

No

230

Each

959.0000

60

60



Handwritten: 4/04/27

SCREW

Location

Loc Qty

Loc Code

FP

63

115336

63

ST293

896

115589

347

116022

148

116373

400

19185

1

Handwritten: 860

NAS1149C0332R

Purchased

No

230

Each

1,958.000

60

60



Handwritten: 4/04/27

Washer

Location

Loc Qty

Loc Code

ST297

1958

115000

125

115698

35

116025

28

116304

1770

Handwritten: 1117291

Handwritten: 860

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

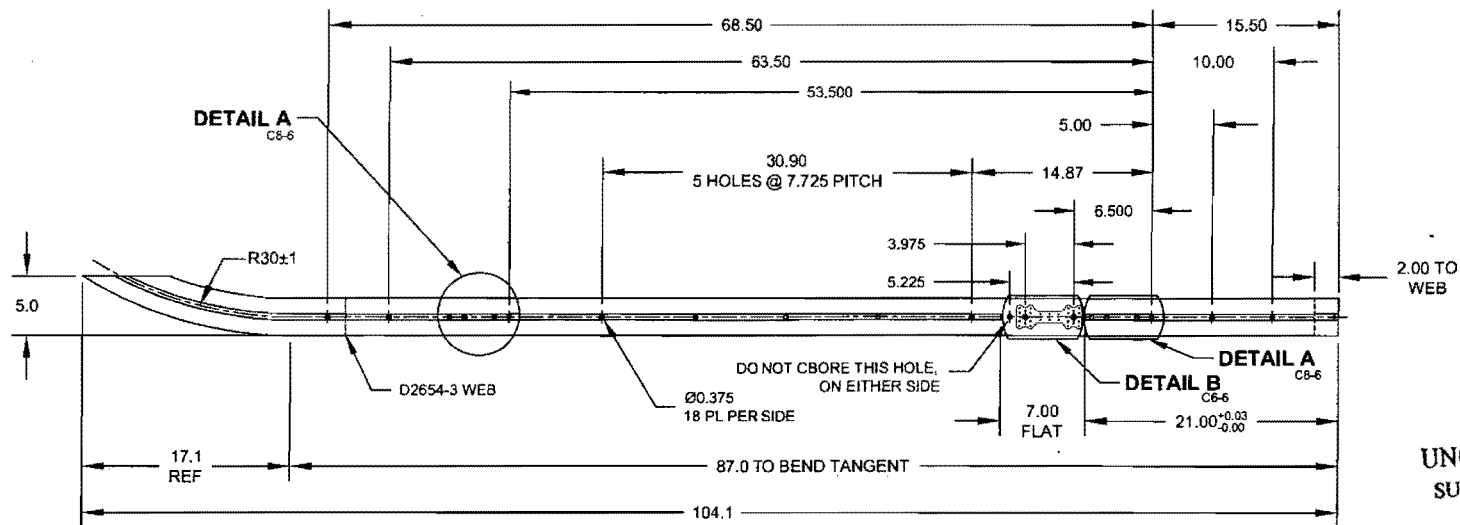
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67251
CZ11/03/14

RELEASED
08-07-23

NOTES:

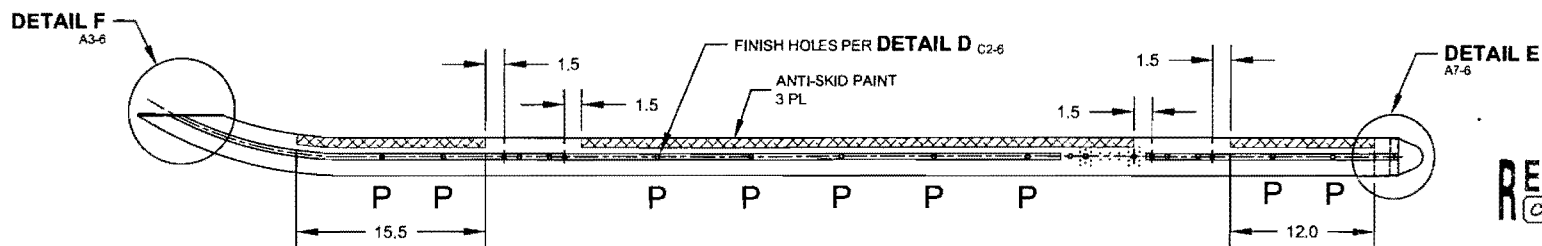
- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER
DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE
GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A
MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5
TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DEC9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. F
MFG. APPR.	<u>[Signature]</u>	D2650	SHEET 1 OF 6
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	







D2650-3 BENDING/DRILLING DETAIL

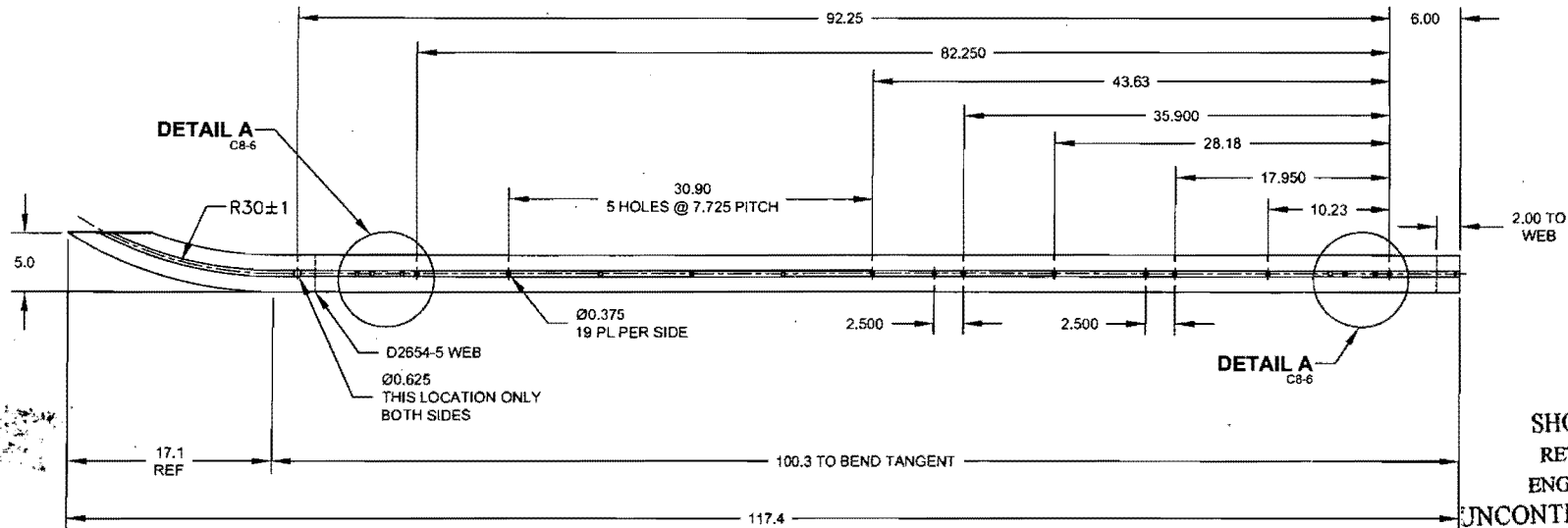
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67251



D2650-3 ASSEMBLY/FINISHING DETAIL

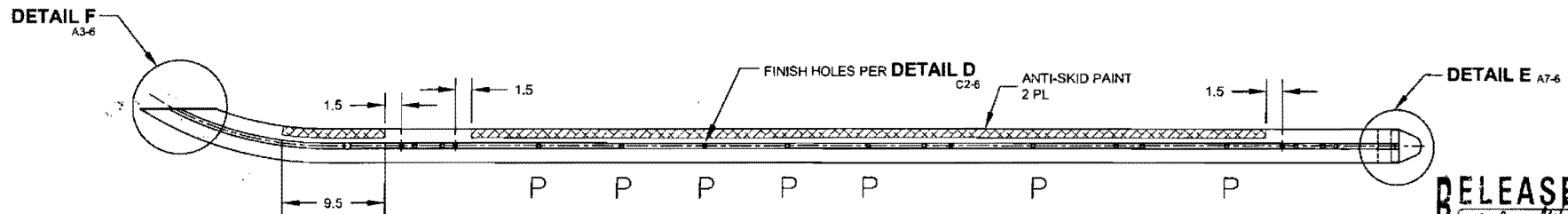
RELEASED
08-07-02

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			







D2650-5 BENDING/DRILLING DETAIL

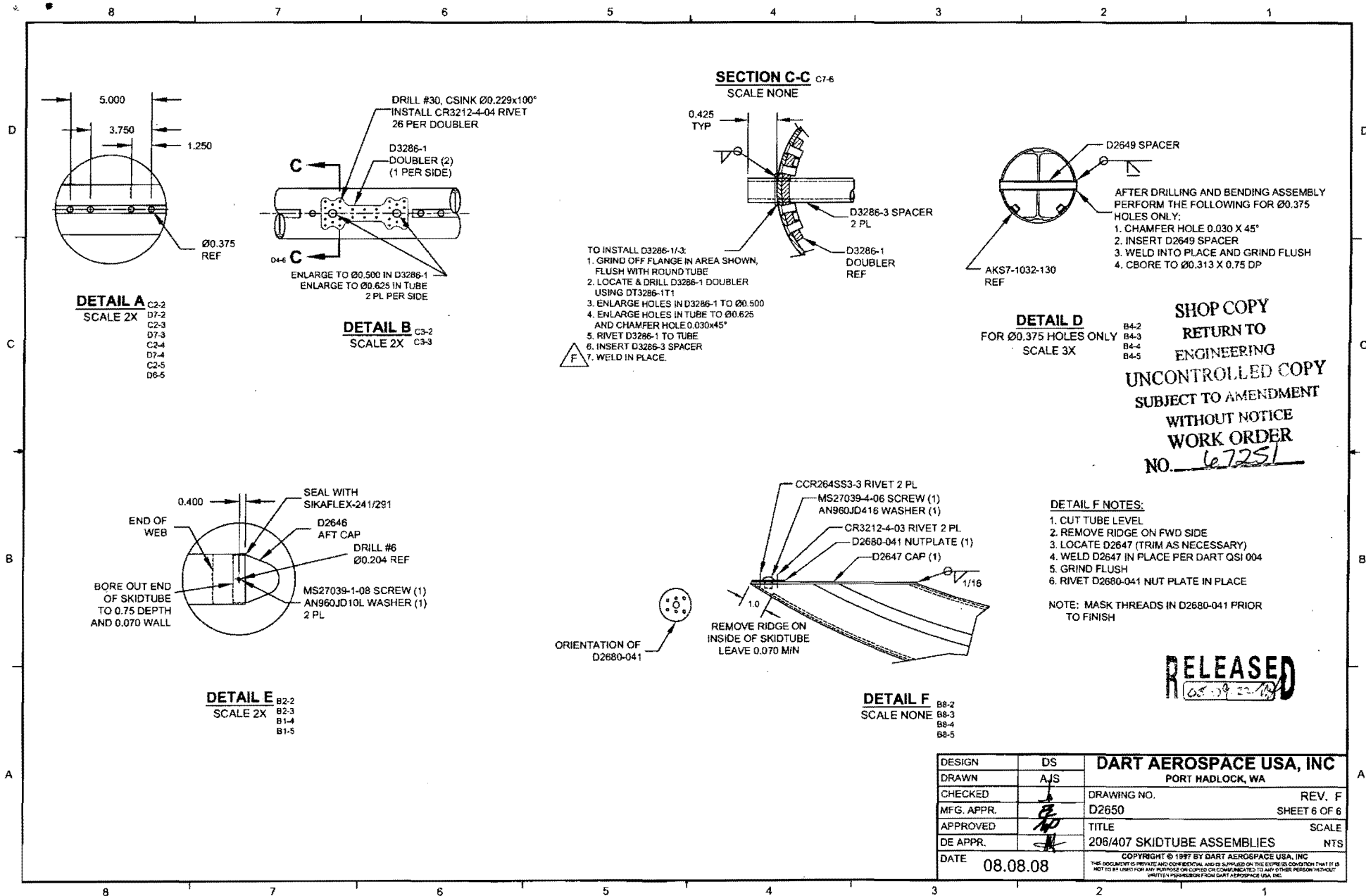
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67251



D2650-5 ASSEMBLY/FINISHING DETAIL

RELEASED
08-09-22/11/17

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



NO. 246

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barklay Elliott
Job number: 66462
Part number: D206-642-441
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Lat Lewis Date of Test Coupon 11-03-09
Welder Barklay Elliott Date of Test Coupon 11-03-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld